

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014705**Date Inspected:** 31-May-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1200**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2400**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

**CWI Name:** Gao Zhi Chun  
**Inspected CWI report:** Yes No N/A  
**Electrode to specification:** Yes No N/A  
**Qualified Welders:** Yes No N/A  
**Approved Drawings:** Yes No N/A

**CWI Present:** Yes No  
**Rod Oven in Use:** Yes No N/A  
**Weld Procedures Followed:** Yes No N/A  
**Verified Joint Fit-up:** Yes No N/A  
**Approved WPS:** Yes No N/A  
**Delayed / Cancelled:** Yes No N/A

**Bridge No:** 34-0006**Component:** OBG and Tower**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector Larry Viars was present during the times noted above for observations relative to the work being performed.

OBG Trial Assembly-

This QA Inspector performed Ultrasonic Testing (UT) on approximately 10% of deck panel to edge panel holdback weld, CA047-006(8AW) previously tested and accepted by ZPMC Ultrasonic Technicians in accordance with AWS D1.2 (2002), section 6, table 6.3 and "Detection of Transverse Discontinuities with Significant Flaw Height Dimension Procedure". This QA Inspector generated a TL -6027 report on this date.

Bay 10-

Caltrans QA Inspector observed the following work in progress: Shielded Metal Arc Welding (SMAW) of the South Tower connection plate weld, SSD1-SPSA5-19-2B. ZPMC welder was identified as 052930. ZPMC CWI was identified as Gao Zhi Chun. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-3211-TC-U5b-1.

Shielded Metal Arc Welding (SMAW) of the South Tower connection plate weld, SSD1-SPSA5-16-2A. ZPMC welder was identified as 050289. ZPMC CWI was identified as Gao Zhi Chun. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-3211-TC-U5b-1.

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## WELDING INSPECTION REPORT

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Flux Cored Arc Welding (FCAW) of East Tower shear plate weld, ED1-A27 B/E-78, 79 and 89. ZPMC welders was identified as 053116, 040302, 054069. ZPMC CWI was identified as Gao Zhi Chun. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2331-TC-P4.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

As identified within the contents of this report.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 150 0042 2372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Viars,Larry	Quality Assurance Inspector
<b>Reviewed By:</b>	McClendon,Timothy	QA Reviewer

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